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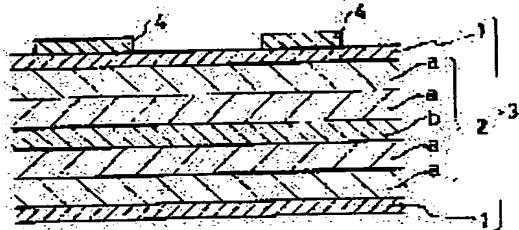
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(54) BULLETIN BOARD FOR ELECTRON

(57)Abstract:

PURPOSE: To propose a bulletin board for election which is formed by using regenerated waste paper and is used for sticking posters of candidates for election.

CONSTITUTION: This bulletin board 3 for election is constituted by joining water-resistant films 1 which include 2 to 8wt.% inorg. fine powder, are ≥60% in the whiteness stipulated in JIS(Japanese Industrial Standards) P 8123 and are ≥50% in the opacity stipulated by JIS-P 8183 to both surfaces of a board 2 formed by sticking multiple layers of water-resistant paper boards a, b which consist of ≥75wt.% regenerated waste paper, are ≤30g/m² water absorption degree in a one minute cup method stipulated in JIS-P 8140 and ≤ 60% weight increasing rate after immersion in water for 24 hours to a thickness 2 to 5mm.



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CLAIMS

[Claim(s)]

[Claim 1] The water absorbing capacity in the 1-minute cob method specified to JIS-P8140 by playback used paper consisting of 75 % of the weight or more is 30 g/m². Following, To both sides of the board which carried out multilayer pasting of the waterproof paper board whose submersion weight rate of increase is 60% or less for 24 hours, and was made into the thickness of 2~5mm The notice plate for Election characterized by the whiteness degree specified by JIS-P8123 including the non-subtlety fine powder end of 2 ~ 8 % of the weight coming to join the waterproof film whose opacity specified by JIS-P8138 is 50% or more 60% or more.

[Claim 2] The notice plate for Election according to claim 1 characterized by laminating this polyethylene film and coming to join using the polyethylene film which carried out corona discharge treatment of the front face as a waterproof film.

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DETAILED DESCRIPTION

[Detailed Description of the Invention]

[0001]

[Industrial Application] This invention relates to the notice plate for Election for sticking the poster of the Election candidate who used playback used paper.

[0002]

[Description of the Prior Art] Conventionally, as a notice plate for Election for making a candidate's poster paste together in various kinds of Election, the 3.5-4mm plywood simple substance, the thing which pasted together and produced the blank paper on the front face of a plywood, the thing which painted the waterproof white coating on the front face of a plywood, or printed waterproof white ink, or the thing using the panel made from aluminum was used.

[0003] In a plywood simple substance, soiled the circumference of a notice plate, or expanded and contracted, and it deformed, or the bitter taste of a pitch came out from the interior by the rainfall etc., the grain pattern and color of a plywood were transparent, and there was a fault, like the alphabetic character and photograph of a poster of the Election candidate become indistinct.

[spoiling an appearance] Since what pasted the blank paper together on the surface of the plywood had the very bad water resisting property, peeling, a tear, etc. generated it frequently by the rainfall. Moreover, it is bad (especially silk screen printing etc.), and, as for a water resisting property, adhesion or drying were not [what applied a waterproof white coating and ink on the surface of the plywood] enough. Furthermore, although the thing using the panel made from aluminum had the high water resisting property, it had the problem that it was expensive and **** was not made.

[0004] Then, the manufacture approach that opacity (JIS-P8138) prints a framework and a notice number in offset ink beforehand at 90% or more on the front face of 90% or more of waterproof resin film, and a whiteness degree (JIS-L1074) makes this paste together with a plywood and adhesives is indicated by JP,5-72985,A.

[0005]

[Problem(s) to be Solved by the Invention] However, since the above-mentioned manufacture approach as well as the various above-mentioned notice plates for Election is a thing using a plywood, it has the following problems. That is, felling of raw material wood carries out, countries in Southeast Asia, such as Malaysia, are anxious about ****, and unwillingness is beginning to be shown in export, and a market condition is also unstable. Furthermore, since this plywood does not have the usage after use besides collecting and burning, it is not desirable from the field of resource protection. In addition, while in use, storm sewage etc. permeates a plywood from the part which the waterproof resin film fractured, or nailing **** and a pin **** part, the bitter taste of a pitch comes out as mentioned above, a poor appearance is caused or the notice plate for Election produced by the above-mentioned manufacture approach causes deformation by telescopic motion. Moreover, since moisture penetrates a waterproof resin film and trespasses upon the interior even if fracture does not arise on a waterproof resin film, a plywood will absorb moisture and will produce deformation etc. Furthermore, since it is necessary to do the activity which applies adhesives, and the activity stuck by pressure at the process which pastes a waterproof resin film together to a plywood, working capacity is bad.

[0006]

[Means for Solving the Problem] This invention was proposed in view of the above, and playback used paper consists of 75 % of the weight or more. The water absorbing capacity in the 1-minute cob method specified to JIS-P8140 is 30 g/m². Following, To both sides of the board which carried out multilayer pasting of the waterproof paper board whose submersion weight rate of increase is 60% or less for 24 hours, and was made into the thickness of 2-5mm The whiteness degree specified by JIS-P8123 including the non-subtlety fine powder end of 2 - 8 % of the weight is related with the notice plate for Election characterized by coming to join the waterproof film whose opacity specified by JIS-P8138 is 50% or more 60% or more.

[0007] The waterproof paper board used for above-mentioned this invention consists more than of 75% weight of playback used paper, and it is desirable as the above-mentioned playback used paper to use the thing of continuous glass fibers with which the waist became brave, such as a corrugated board and wrapping. Specifically in the suspension of the fiber raw material which consists of the 100% of the above-mentioned playback used paper, playback used paper, and pulp The humid paper reinforcing agent which uses as a principal component the desiccation paper reinforcing agent which uses the rosin size agent for making a water resisting property give, and a synthetic sizing compound as a principal component for poly acrylamide resin etc. and a urea-resin, melamine resin, an epoxy resin, etc., Internal [of the sulfuric-acid band for fixing these to a fiber raw material] is carried out, respectively, and after carrying out paper formation, it can be made to be able to dehydrate and dry and can produce. And for the waterproof paper board produced to this appearance, the water absorbing capacity (g display of the moisture weight which absorbs water in 1 minute after the front face of 2 1m is done) in the 1-minute cob method specified to JIS-P8140 is 30 g/m². Following, The submersion weight rate of increase (after the sample cut out in the 10cmx10cm dimension is immersed in water for 24 hours, surface moisture is removed and measured through a filter paper, and it expresses with the weight rate of increase to the original weight) has 60% or less of high water resisting property for 24 hours.

[0008] And multilayer pasting of the above-mentioned waterproof paper board is carried out, it is made the thickness of 2-5mm, and a board is produced. In addition, what is necessary is just to cut pasting of the above-mentioned waterproof paper board in a predetermined dimension, after carrying out pressurization junction using the water resistant adhesive of for example, a polyvinyl alcohol system or a polyvinyl acetate system etc.

[0009] The waterproof film joined to both sides of the above-mentioned board mixes the end of non-subtlety fine powder, such as 0.02-3-micrometer titanium oxide, talc, baking clay, a calcium carbonate, and diatomaceous earth, to raw material resin, such as polyethylene, polypropylene, ethylene propylene rubber, polystyrene, and polyethylene terephthalate, and is fabricated in the shape of a film. And 60% or more of high whiteness degree and the opacity specified by JIS-P8138 make 50% or more of high concealment nature hold, and in exterior vanity, the whiteness degree specified by JIS-P8123 makes the color of the waterproof paper board used as a substrate etc. there be nothing, and makes vivid the color of printing performed to the front face etc. In addition, the film shaping approach should just select suitably the well-known processing approaches, such as a T-die extrusion method, the calender method, and the casting method.

[0010] Moreover, the approach of joining the above-mentioned waterproof film to both sides of a board may be pasted together using adhesives and binders, such as hot melt adhesive, and may be laminated as it is.

[0011] Especially with the waterproof film which selected and produced polyethylene as raw material resin, if a lamination can perform junction on a board and corona discharge treatment of that front face is carried out in this case, the ink adhesion in various printings improves, and also in case a candidate's poster is stuck with adhesives, an adhesive property will improve.

Moreover, what is necessary is just to print a framework and a notice number by flexographic printing, also when there is sudden Election by parliamentary dismissal etc.

[0012]

[Function] Since a plywood was not used for the notice plate for Election of this invention which has the above-mentioned configuration, although it contributes to environmental protection and

the conventional plywood was used for it, it does not produce a poor appearance by a rainfall etc. like, or it does not expand, contract and transform it. Furthermore, since stability and planned manufacture can be performed and it can collect after use, since available playback used paper is used for stability, and it can reuse as used paper, a great contribution is carried out also to resource protection. In addition, since the waterproof film has prevented exposure of a board, the appearance is beautiful and ***** is also possible for it. Since especially the thing using the polyethylene film which carried out corona discharge treatment to the front face as a waterproof film can perform junction on a board by lamination, it turns into what has high working capacity.

[0013]

[Example]

the inside of the suspension which uses as a fiber raw material 75 % of the weight and 25 % of the weight of pulp, such as corrugated paper used paper which carried out [manufacture of the waterproof paper board] recovery, — solid part conversion — a fiber raw material — receiving — a rosin size agent — 1.5%, internal [of the 0.3% / of desiccation paper reinforcing agents /, 0.1% / of humid paper reinforcing agents /, and sulfuric-acid band 6%] was carried out, respectively, and basis-weight 500 g/m², the waterproof paper board a with a thickness of 0.73mm and basis-weight 370 g/m², and the waterproof paper board b a thickness of 0.53mm be produced. For the two above-mentioned sorts of waterproof paper boards a and b, the water absorbing capacity in the 1-minute cob method specified to JIS-P8140 is 18 g/m². The 24-hour submersion weight rate of increase was 45%.

[0014] [manufacture of a board] — the board 2 which carried out the laminating of the two-layer waterproof paper board a to both sides of the waterproof paper board b produced as mentioned above, and was made into a total of five layer structures as shown in drawing 1 was produced. In addition, the junction to the waterproof paper board a, a, and the waterproof paper board a and the waterproof paper board b pasted up polyvinyl alcohol as adhesives, respectively. The thickness of the above-mentioned board 2 was 3.5mm.

[0015] 95kg of [manufacture of waterproof film] polyethylene resin and 5kg of titanium oxide before and behind the particle size of 0.2 micrometers were fully kneaded, and the waterproof film 1 with a thickness of 32 micrometers was produced with the T-die extrusion method. Thickness was 32 micrometers and the opacity of the above-mentioned waterproof film 1 which the whiteness degree specified by JIS-P8123 is 93%, and specifies by JIS-P8138 was 75%.

[0016] Said waterproof film 1 was stuck to both sides of the [manufacture of notice plate for Election] aforementioned board 2 by pressure with the extrusion laminator, and the notice plate 3 for Election (substrate) as shown in drawing 1 was produced. In addition, four are printing ink among drawing. The obtained notice plate 3 for Election was 3.5mm in basis-weight 2470 g/m² and thickness, and the 24-hour submersion weight rate of increase was 6%.

[0017] as mentioned above — unless the configuration which this invention is not limited to said example carried out, and was indicated to the claim although explained based on the example of this invention is changed — how — also coming out — it can carry out.

[0018]

[Effect of the Invention] As explained above, the notice plate for Election of this invention is the configuration that a whiteness degree and concealment nature joined the waterproof high film to both sides of the board which has the high water resisting property which uses playback used paper as a raw material, and since a plywood is not used like before, it contributes to environmental protection. Moreover, since the board in this invention consists of the waterproof paper boards which have a very high water resisting property, although it used the conventional plywood, it does not produce a poor appearance by a rainfall etc. like, or does not expand, contract and transform it. Furthermore, since playback used paper available to stability is used for this invention as a raw material, it is not influenced by the market condition like before and stability and planned manufacture can be performed. Moreover, since it can collect after use and can reuse as used paper, a great contribution is carried out also to resource protection. In addition, since the waterproof film has prevented exposure of a board, the appearance is beautiful and ***** is also possible for it.

[0019] Since especially the thing using the polyethylene film which carried out corona discharge

treatment to the front face as a waterproof film can perform junction on a board by lamination, it turns into what has very high working capacity. Moreover, what is necessary is just to print a framework and a notice number by flexographic printing, also when there is sudden Election by parliamentary dismissal etc.

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DESCRIPTION OF DRAWINGS

[Brief Description of the Drawings]

[Drawing 1] It is the sectional view showing the cross-section configuration of the notice plate for Election of this invention.

[Description of Notations]

The waterproof paper board

b The waterproof paper board

1 Waterproof Film

2 Board

3 Notice Plate for Election

4 Printing Ink

[Translation done.]

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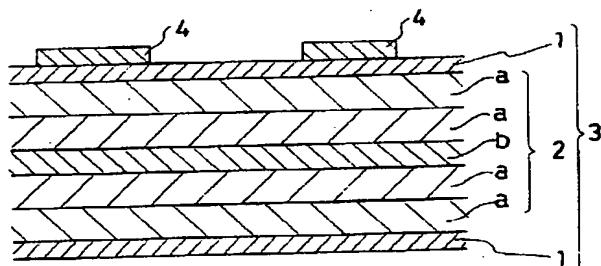
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(54)【発明の名称】 選挙用掲示板

(57)【要約】

【目的】 再生古紙を用いた、選挙立候補者のポスターを貼るための選挙用掲示板を提案する。

【構成】 再生古紙が75重量%以上からなり、JIS-P8140に規定する1分コップ法における吸水度が30g/m²以下、24時間水浸重量増加率が60%以下である耐水板紙a、bを、多層貼合して2~5mmの厚さにしたボード2の両面に、2~8重量%の無機微細粉末を含んでJIS-P8123で規定する白色度が60%以上、JIS-P8138で規定する不透明度が50%以上である耐水性フィルム1を接合して選挙用掲示板3を構成する。



【特許請求の範囲】

【請求項1】 再生古紙が75重量%以上からなり、JIS-P8140に規定する1分コップ法における吸水度が 30 g/m^2 以下、24時間水浸重量増加率が60%以下である耐水板紙を、多層貼合して2~5mmの厚さにしたボードの両面に、2~8重量%の無機微細粉末を含んでJIS-P8123で規定する白色度が60%以上、JIS-P8138で規定する不透明度が50%以上である耐水性フィルムを接合してなることを特徴とする選挙用掲示板。

【請求項2】 耐水性フィルムとして表面をコロナ放電処理したポリエチレンフィルムを用い、該ポリエチレンフィルムをラミネートして接合してなることを特徴とする請求項1に記載の選挙用掲示板。

【発明の詳細な説明】

【0001】

【産業上の利用分野】 本発明は、再生古紙を用いた、選挙立候補者のポスターを貼るための選挙用掲示板に関するものである。

【0002】

【従来の技術】 従来、各種の選挙において立候補者のポスターを貼合させるための選挙用掲示板としては、3.5~4mmの合板単体、合板の表面に白紙を貼合して作製したもの、合板の表面に耐水性白色塗料を塗装したり耐水性白色インクを印刷したもの、或いはアルミ製のパネルを用いたものなどが使用されていた。

【0003】 合板単体では、降雨等により内部から樹脂分のアクリルが出て外観を損なったり、掲示板の周辺を汚したり、伸縮して変形したり、或いは合板の木目模様や色彩が透けて選挙立候補者のポスターの文字や写真が不鮮明になる等の欠点があった。合板の表面に白紙を貼合したものは、耐水性が極めて悪いため降雨により剥れや破れ等が頻繁に発生した。また、合板の表面に耐水性白色塗料やインクを塗布したものは、密着性や乾燥性が悪く（特にシルクスクリーン印刷等）、耐水性もまた十分ではなかった。さらに、アルミ製のパネルを用いたものは、高い耐水性を有するものの、高価であり、釘打ちができないという問題があった。

【0004】 そこで、不透明度（JIS-P8138）が90%以上で、白色度（JIS-L1074）が90%以上の耐水性樹脂フィルムの表面に、予め枠組みと掲示番号をオフセットインキで印刷し、これを合板と接着剤で貼合せる製造方法が、特開平5-72985号公報に開示されている。

【0005】

【発明が解決しようとする課題】 しかしながら、上記製造方法も、前述の各種選挙用掲示板と同様に合板を用いるものであるため、以下のような問題がある。即ち、マレーシアなど東南アジア諸国が原料木材の伐採のし過ぎを懸念して輸出に難色を示し始めており、また市況も不

安定である。さらに、この合板は使用後には回収して燃焼する以外に利用方法がないため、資源保護の面からも好ましくはない。加えて、上記製造方法により作製された選挙用掲示板は、使用中に耐水性樹脂フィルムが破断した部分、或いは釘打ち部分やピン打ち部分から雨水等が合板に浸透し、前述のように樹脂分のアクリルが出て外観不良を起したり、伸縮による変形を起す。また、耐水性樹脂フィルムには破断が生じなくても、水分は耐水性樹脂フィルムを透過して内部に侵入するので、合板が水分を吸収して変形等を生じてしまう。さらに、耐水性樹脂フィルムを合板に貼合する工程では、接着剤を塗布する作業と圧着する作業とを行う必要があるために作業能率が悪い。

【0006】

【課題を解決するための手段】 本発明は上記に鑑み提案されたもので、再生古紙が75重量%以上からなり、JIS-P8140に規定する1分コップ法における吸水度が 30 g/m^2 以下、24時間水浸重量増加率が60%以下である耐水板紙を、多層貼合して2~5mmの厚さにしたボードの両面に、2~8重量%の無機微細粉末を含んでJIS-P8123で規定する白色度が60%以上、JIS-P8138で規定する不透明度が50%以上である耐水性フィルムを接合してなることを特徴とする選挙用掲示板に関するものである。

【0007】 上記本発明に用いる耐水板紙は、再生古紙75%重量以上からなり、上記再生古紙としては段ボール紙や包装紙など腰のしっかりした長纖維のものを用いることが好ましい。具体的には、上記再生古紙100%又は再生古紙とバルプとからなる纖維原料の懸濁液中に、耐水性を付与させるためのロジンサイズ剤、合成サイズ剤をポリアクリルアミド樹脂等を主成分とする乾燥紙力増強剤及び尿素樹脂、メラミン樹脂、エポキシ樹脂等を主成分とする湿潤紙力増強剤と、これらを纖維原料に定着させるための硫酸バンドをそれぞれ内添して紙層形成せしめた後、脱水、乾燥させて作製することができる。そして、この様に作製した耐水板紙は、JIS-P8140に規定する1分コップ法における吸水度（ 1 m^2 の表面から1分間に吸水する水分重量をg表示する）が 30 g/m^2 以下、24時間水浸重量増加率（ $10\text{ cm} \times 10\text{ cm}$ の寸法に断裁したサンプルを24時間水に浸漬した後、ろ紙で表面の水分を取り除いて計量し、元の重量に対して重量増加率で表す）が60%以下の高い耐水性を有するものである。

【0008】 そして、上記耐水板紙を多層貼合して2~5mmの厚さにし、ボードを作製する。尚、上記耐水板紙の貼合は、例えはポリビニルアルコール系やポリ酢酸ビニル系の耐水性接着剤等を用いて加圧接合した後、所定の寸法に切断すればよい。

【0009】 上記ボードの両面に接合する耐水性フィルムは、 $0.02\text{ }\mu\text{m}$ ~ $3\text{ }\mu\text{m}$ の酸化チタン、タルク、焼成ク

レー、炭酸カルシウム、珪藻土等の無機微細粉末を、ポリエチレン、ポリプロピレン、エチレン・プロピレン共重合体、ポリスチレン、ポリエチレンテレフタレート等の原料樹脂に混合してフィルム状に成形される。そして、JIS-P8123で規定する白色度が60%以上の高い白色度と、JIS-P8138で規定する不透明度が50%以上の高い隠蔽性とを保有させ、下地となる耐水板紙の色等を外観上見えなくし、その表面に施す印刷の色等を鮮やかにする。尚、フィルム成形方法は、Tダイ押出法、カレンダー法、キャスティング法等の公知の加工方法を適宜に選定すればよい。

【0010】また、上記耐水性フィルムをボードの両面に接合する方法は、ホットメルト接着剤等の接着剤や粘着剤を用いて貼合するものでも良いし、そのままラミネートするものでもよい。

【0011】特に、原料樹脂としてポリエチレンを選定して作製した耐水性フィルムでは、ボードへの接合をラミネートにより行うことができ、この場合、その表面をコロナ放電処理すれば、各種印刷におけるインク密着性が向上し、立候補者のポスターを接着剤で貼る際にも接着性が向上する。また、議会の解散等による急な選挙がある場合にも、フレキソ印刷で枠組みや掲示番号を印刷すれば良い。

【0012】

【作用】上記構成を有する本発明の選挙用掲示板は、合板を用いないで環境保護に貢献するものであり、また従来の合板を用いたもののように降雨等により外観不良を生じたり、伸縮して変形することもない。さらに、安定入手可能な再生古紙を用いるので、安定且つ計画的な製造を行うことができるし、使用後に回収して古紙として再利用することができるので、資源保護にも多大な貢献をするものである。加えて、耐水性フィルムがボードの露出を防いでいるので、外観は美麗であり、釘打ちも可能である。特に、耐水性フィルムとして表面にコロナ放電処理したポリエチレンフィルムを用いたものは、ボードとの接合をラミネートにより行うことができるので、作業能率が高いものとなる。

【0013】

【実施例】

【耐水板紙の製造】回収した段ボール古紙等75重量%とパルプ25重量%とを繊維原料とする懸濁液中に、固型分換算で繊維原料に対してロジンサイズ剤1.5%、乾燥紙力増強剤0.3%、湿潤紙力増強剤0.1%、硫酸バンド6%をそれぞれ内添して坪量500g/m²、厚さ0.73mmの耐水板紙aと、坪量370g/m²、厚さ0.53mmの耐水板紙bとを作製した。上記2種の耐水板紙a、bは、JIS-P8140に規定する1分コップ法における吸水度が18g/m²で、24時間水浸重量増加率が4.5%であった。

【0014】【ボードの製造】前記のように作製した耐

水板紙bの両面に、2層の耐水板紙aを積層し、図1に示すような合計5層構造としたボード2を作製した。尚、耐水板紙a、aどうし、及び耐水板紙aと耐水板紙bとの接合は、それぞれポリビニルアルコールを接着剤として接着した。上記ボード2は、厚みが3.5mmであった。

【0015】【耐水性フィルムの製造】ポリエチレン樹脂95kgと、粒径0.2μm前後の酸化チタン5kgとを充分に混練し、Tダイ押出法により厚さ32μmの耐水性フィルム1を作製した。上記耐水性フィルム1は、厚みが32μmであり、JIS-P8123で規定する白色度が93%で、JIS-P8138で規定する不透明度が75%であった。

【0016】【選挙用掲示板の製造】前記ボード2の両面に、前記耐水性フィルム1をエクストルージョンラミネータにより圧着し、図1に示すような選挙用掲示板(基板)3を作製した。尚、図中、4は印刷インクである。得られた選挙用掲示板3は、坪量2470g/m²、厚さ3.5mmであり、24時間水浸重量増加率が6%であった。

【0017】以上、本発明の実施例に基づいて説明したが、本発明は前記した実施例に限定されるものではなく、特許請求の範囲に記載した構成を変更しない限りどのようにでも実施することができる。

【0018】

【発明の効果】以上説明したように本発明の選挙用掲示板は、再生古紙を原料とする高い耐水性を有するボードの両面に、白色度及び隠蔽性が高い耐水性フィルムを接合した構成であって、従来のように合板を用いるものではないので、環境保護に貢献するものである。また、本発明におけるボードは極めて高い耐水性を有する耐水板紙から構成されているので、従来の合板を用いたもののように降雨等により外観不良を生じたり、伸縮して変形することができない。さらに、本発明には、原材料として安定入手可能な再生古紙を用いるので、従来のように市況に影響されることがなく安定且つ計画的な製造を行うことができる。また、使用後に回収して古紙として再利用することができるので、資源保護にも多大な貢献をする。加えて、耐水性フィルムがボードの露出を防いでいるので、外観は美しい釘打ちも可能である。

【0019】特に、耐水性フィルムとして表面にコロナ放電処理したポリエチレンフィルムを用いたものは、ボードとの接合をラミネートにより行うことができるので、作業能率が極めて高いものとなる。また、議会の解散等による急な選挙がある場合にも、フレキソ印刷で枠組みや掲示番号を印刷すれば良い。

【図面の簡単な説明】

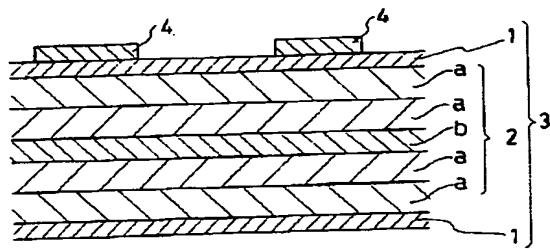
【図1】本発明の選挙用掲示板の断面構成を示す断面図である。

【符号の説明】

- a 耐水板紙
- b 耐水板紙
- 1 耐水性フィルム

- 2 ボード
- 3 選挙用掲示板
- 4 印刷インク

【図1】



フロントページの続き

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